Step 8 **CRANKSHAFT:** Sheet #7

Part: #108

Material: 2½" x 1" x 14" CRS.

Procedure: Lay out and drill centers. Drill and saw crankshaft blank as shown. Turn and polish rod journal. Saw off its centers. Install crankshaft jack as shown. Now turn and polish mains. Keyways can be hand cut in the lathe. Locate keyways as shown.

Step 9 **TIMING GEARS and CRANKSHAFT SPACER:** Sheet #7

Parts: #109, #110, and #111

Material: Gear castiron 60T - 16 pitch 14½ degrees P.A.
Gear steel 30T - 16 pitch 14½ degrees P.A., $1^1/_8$" dia. x ½" CRS.

Procedure: Bore 30T (#110) for 0.001" - 0.0015" shrink fit on crankshaft, heat and push in place. Face hub side of 60T gear (#111). Bore, drill, and tap for set screws. Turn crankshaft spacer.

Step 10 **CONNECTING ROD and CONNECTING ROD BEARING:** Sheet #2

Parts: #112, #113, and #X15

Materials: $^3/_8$" black pipe x 7", $^1/_8$" pipe coupling, ¾" dia. x 2" CRS., ¾" x ¼" x $2^1/_8$" CRS., 2" x 2" x ¼" CRS., 1" x ¼" x 2¼" CRS., $^1/_8$" x ½" x 1½" CRS., 1" x 1" x 4½" aluminum.

Procedure: Connecting rod blocks (#113): Size aluminum blocks with 4-jaw. Clamp together with the ¼" x ¾" x $2^1/_8$" CRS., drill and tap. Mark for reassembly. Bolt aluminum blocks together, bore and face both sides. Drill the 4 babbitt anchor holes in each block as shown.

(Procedure continues on following page.)